



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3319-3
Job Sheet 181959



Part No: D3319-3

Job Qty: 6 ea

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/14/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Waterjet		SC 18/09/18
100	Waterjet	3 pcs	8/31/18	8/31/18	0.00	0.70	Waterjet1		SC 18/09/18
110	QC	3 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Waterjet-2		SC 18/09/18 DAS
120	QC	3 pcs	8/31/18	8/31/18	0.00	0.00	QC8-2		SEP 06 2018 68
140	Brake NC	6 pcs	8/31/18	8/31/18	0.12	0.42	Brake NC 1		9-89
150	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC5		OCT 31 2018 68
160	Autoweld 1	6 pcs	8/31/18	8/31/18	0.00	1.91	Automated welding		9-89
170	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC10		EL
180	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC5		EL
190	SprayPaint	6 pcs	8/31/18	8/31/18	0.00	0.60	Spray Paint		11/08/18 DAS
200	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC3		AT 18/11/18 68
210	Packaging	6 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-1		NOV 09 2018 68
220	QC21-SA	6 Ea	8/31/18	8/31/18	0.00	0.00	QC21		NOV 09 2018 68

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary

Descriptions: 140 - Form using DT8326 & DT8261 as per Dwg D3319

160 - 8259 Hardcoat Rod

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.

BATCH: 138949 9/1/19

210 - Identify on inside surface using a permanent fine point marker with the following:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	9.7500 sf (3.25 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S18GA	10	148	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches	0.195	0.194	

6:30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____ Step #: _____ QTY Effective : _____ MRB (OSI) Approval _____

Description Work Order Deviation	Disposition

DART Aerospace Ltd.
 1270 Aberdeen Street
 Hamilton, ON K8A 1K7
 CANADA
 TEL : 1 613 632-6200
 Email: sales@dartaero.com
 www.dartaero.com

Part: D3319-3
 Job No: 181959
 Serial No/Batch: S107571
 Revision: D
 Inspector: _____
 Exp Date: _____
 Instructions: Various STC's

Container No: S107571
 Date: 09/02/18

Root Cause		Other	
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Part Lost/Missing ☐
Design ☐	Operator ☐	Bending ☐	Part Moved ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Drawing ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Finish ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Misread ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Turning Sequence ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	
Past Expiry Date ☐	Manufacturing Process ☐	Instructions Incomplete/Unclear ☐	
Misidentified ☐	Past Due ☐	Drill Holes ☐	
		OTHER : _____	

			+ 0.005	0.189	
			- 0.001		
2	Wearplate	0.500inches	+ 0.006 - 0.001	0.506 0.499	0,503
3	Wearplate	0.316inches	± 0.010	0.326 0.306	0,315
4	Wearplate	0.607inches	± 0.010	0.617 0.597	0,610
5	Wearplate	2.940inches	± 0.030	2.970 2.910	2,943
6	Wearplate	2.690inches	± 0.030	2.720 2.660	2,694
7	Wearplate	3.527inches	± 0.010	3.537 3.517	3,530
8	Wearplate	4.520inches	± 0.030	4.550 4.490	4,524
9	Wearplate	5.063inches	± 0.010	5.073 5.053	5,066
10	Wearplate	6.160inches	± 0.030	6.190 6.130	6,167
11	Wearplate	0.600inches	± 0.030	0.630 0.570	0,607
12	Wearplate	8.690inches	± 0.010	8.700 8.680	8,698
13	Wearplate	30.790inches	± 0.010	30.800 30.780	30,796
14	Wearplate	52.880inches	± 0.030	52.910 52.850	52,88
15	Wearplate	62.770inches	± 0.010	62.780 62.760	62,77
16	Wearplate	74.420inches	± 0.010	74.430 74.410	74,422
17	Wearplate	75.520inches	± 0.030	75.550 75.490	75,520
18	Wearplate	0.050inches	± 0.010	0.060 0.040	0,047

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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